

# Work Order ID 67827 - 1

Thursday, March 31, 2011 1:19:26 PM

Page 1

Item ID: D2230-3

Accept

Setup Start

Revision ID:

Stop

Item Name: Lug

Start Date: 3/31/2011 Start Qty: 100.00

Cust Item ID:

Required Date: 4/15/2011 Req'd Qty: 100.00

Customer:

Reference:

Approvals: Process Plan: *CL*

Date: 11/03/30 Tooling:

Date:

QC:

Date: SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D2230

Rev G

100



Bandsaw

Jeaspa Bandsaw

BAND SAW

0.00

Memo

0.00

Cut D2423 extrusion to 0.82"

Batch:

*cut @ metec*

110



HAAS I

HAAS CNC vertical machine #1

HAAS CNC VERTICAL MACHINING #1

0.00

Memo

0.00

1-Machine per folio FA927

FOLIO REV.

DWG REV.

Check for crack while loading into the machine

2- deburr

*issue P/O to metec*

*Machine as per dwg D2230 REV. G*

*CL 11/03/31*

*CL 11/03/31 100*

*P/O: 13764*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Page 2

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Cust Item ID:

Required Date: 4/15/2011 Req'd Qty: 100.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

120



QC

Quality Control

QC2 - inspect parts off machine FAI/FAIB

0.00

Memo

0.00

rec'd + inspect for transit damage  
attached c/c to W10

11/14/15 (55)

130



QC

Quality Control

QC6 - inspect parts - second check

0.00

Memo

0.00

11 04 15 (55)

150



HandFinish

Hand Finishing

Chemical Conversion Coat per QS1005 4.1

0.00

Memo

0.00

11/04/15 (X55)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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NOTE: Date & initial all entries

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Page 3

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Setup Start



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Stop



Item Name: Lug

Start Date: 3/31/2011 Start Qty: 100.00



Cust Item ID:

Required Date: 4/15/2011 Req'd Qty: 100.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

55 BR 11-4-18.

170

White Gloss(Ref:4 3 5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME: 10:20

OVEN TEMPERATURE: 320°

FINISH TIME: 10:50

55 BR 11-4-18.

180

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

55 φ 11-4-18



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

**Work Order ID 67827**

Thursday, March 31, 2011 1:19:26 PM



Page 4

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Item Name: Lug

Start Date: 3/31/2011 Start Qty: 100.00



Cust Item ID:

Required Date: 4/15/2011 Req'd Qty: 100.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

190

Identify as per dwg & Stock Location: *5+476*

0.00



Packaging

Memo

0.00

Packaging

*ESa/04/18* *(55)*

200

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

*11/4/18**CME*  
*11-04-18*

# Picklist Print

Thursday, March 31, 2011 1:19:22 PM

Page 1

Work Order ID: 67827



Parent Item: D2230-3

Parent Item Name: Lug


Start Date: 3/31/2011

Required Date: 4/15/2011

Start Qty: 100.00

Required Qty: 100.00

Comments: IPP D' 00.05.18 Added inspection level 8, and removed P/O for powder coat EC  
IPP REV :E NEW FOLIO # 10-05-25 JLM VERIFIED BY:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2423  Lug Extrusion		Manufactured	No			100	f	384.5000	0.0683	7.189474			

Location	Loc Qty	Loc Code
MAT006	384.5	
43722	161.5	
45800	1	
63005	222	

ME 11-04-18  
→

D 2230-3 P

X100

4/4/15 (58)



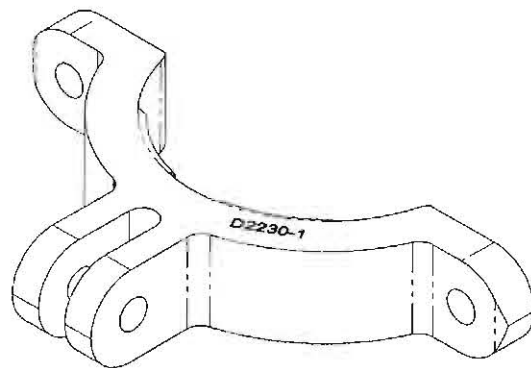
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

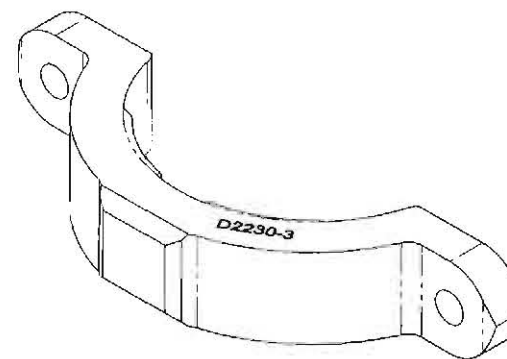
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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NOTE: Date & initial all entries



D2230-1 MOUNTING LUG



D2230-3 MOUNTING LUG

RELEASED  
09/01/16

08/11/03/31  
WFO: 67827

G	REDRAWN IN SOLIDWORKS TO CURRENT DESIGN. STANDARDS REFER TO SECTION A-A & B-B FILLET ADDED TO PREVENT CHAFING OF RUBBER CUSHION ON INSTALLATION	AJS	09.01.16
F	REDESIGN, R1 200 WAS 1 100	CP	99.12.12
E	RE-DESIGN	BW	05.01.04
D	RE-DESIGN	BW	05.01.04
C	RE-DESIGN	BW	04.03.30
REV	DESCRIPTION	BY	DATE
DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO D2230	REV. G SHEET 1 OF 3
MFG. APPR.		TITLE MOUNTING LUG	SCALE N.T.S.
APPROVED		COPYRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT IS UNCLASSIFIED AND IS RELEASED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR FOR DISSEMINATION TO ANY OTHER PERSON WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.	
DE APPR.			
DATE	09.01.16		



**NOTES**

- 1) MATERIAL: MAKE FROM D2423 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART OSI 005 4.1  
POWDER COAT WHITE (4 3 5, 1) PER DART OSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES, 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE PART NUMBER TO A DEPTH OF 0.010 ± 0.005 IN THIS LOCATION, WITH TOOL TIP RADIUS OF 0.015 ± 0.005
- 7) WEIGHT: -1' 0.16 lbs  
-3' 0.14 lbs

SECTION A-A D4.2  
SCALE 2X

R0.06 MIN - R0.10 MAX  
2 PL

0.273 REF

0.306

0.345

R0.125 REF

0.250

0.735 REF

SYM ABOUT

FILLET EDGE  
PER SECTION  
A-A

MACHINE TO  
SIZE

D2230-1

1.91

0.025 REF

0.400

R0.38 REF

0.375

3.700

$\phi 0.257^{+0.005}_{-0.000}$

0.750

R0.38 REF

SYM ABOUT

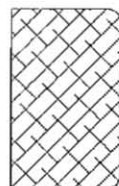
D2230-1 MOUNTING LUG

W/O. 47827

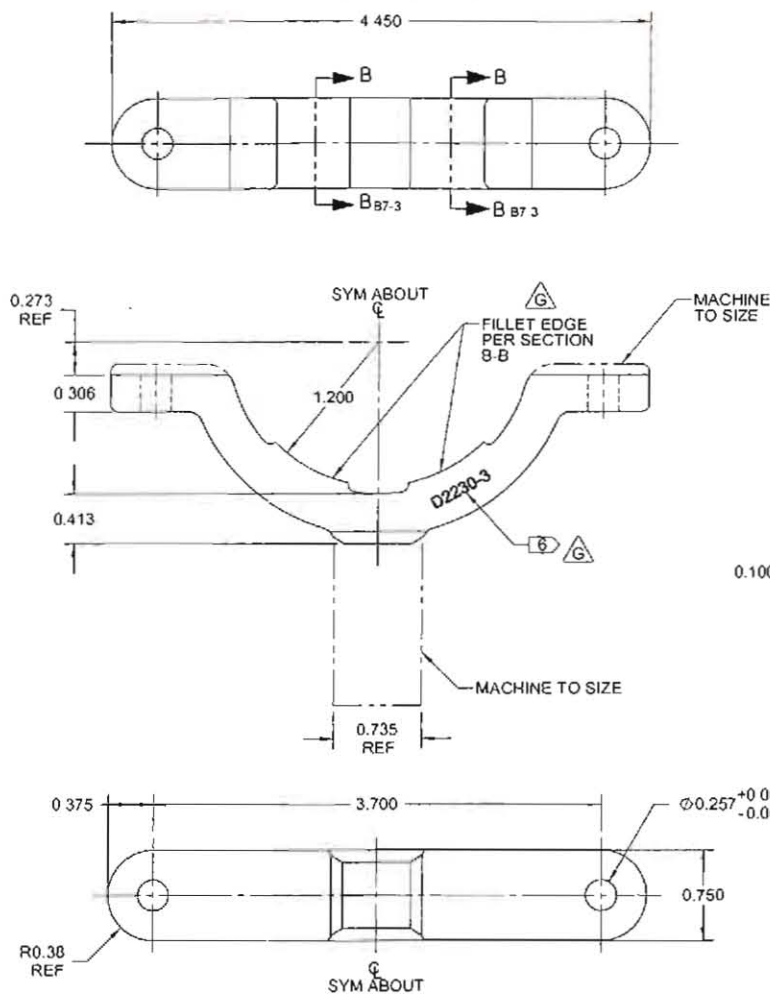
RELEASED  
09/06/25/18

DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO	REV. G
MFG. APPR		D2230	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR		MOUNTING LUG	NTS
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**SECTION B-B**  
SCALE 2X



R0.06 MIN - R0.10 MAX  
2 PL



**D2230-3 MOUNTING LUG**

**RELEASED**  
09/06/75

DESIGN	BW	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	A/S		
CHECKED		DRAWING NO	REV. G
MFG. APPR.		D2230	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		MOUNTING LUG	NTS
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W/O: 67827



20 Terry Fox Drive  
Vankleek Hill, Ontario K0B 1R0  
Tel: (613) 678-3957  
Fax: (613) 678-3956

Delivery Slip No.: **17908**  
Date: Apr 14, 2011  
Page: 1

<b>Sold to:</b>	<b>Ship to:</b>
Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7	Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7
<b>Order No.:</b> 13764	<b>Sold By:</b>
<b>Shipped By:</b> your truck	<b>Ship Date:</b>

Description	Unit	Ordered quantity	Shipped quantity	Backorder quantity
D2230-1 Mounting Lug Material supplied by DART: D2423 B63005	Each	100		100
D2230-3 Mounting Lug Material supplied by DART: D2423 B63005	Each	100	55	45
D3235-1 Mounting Lug Material supplied by DART: D2423 B63005	Each	100	85	15
Received by <u>Henry By</u>		Thank you for your order!		





Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, ON K6A 1K7  
Tel: 613 632 9577  
Fax: 613 632 1053

\*\*\*PO REPRINT\*\*\*

Purchase Order ID PO13764

Purchase Order Date 3/31/2011

PO Print Date 4/6/2011

Page Number 1 of 1

Order From : VC-MET003

METEC METAL TECHNOLOGY INC.  
20 TERRY FOX DRIVE PO BOX 781  
VANKLEEK HILL, QC K0B 1R0  
CA

Contact Name  
Vendor Phone 613 678 3957  
Vendor Fax 613 678 3956  
Vendor Account Nbr

Buyer Chantal Lavoie  
Requisition Nbr  
Tax Resale Nbr 10127-2607  
Terms Net 30  
Currency CAD  
FOB Destination-Collect

REVISED

Ship To : DART AEROSPACE LTD 1270 ABERDEEN  
HAWKESBURY, ON K6A 1K7  
CANADA

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req. Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	D2230-1P	LUG	4/22/2011 Yes	100.00 Each	Dart Truck	\$18.9500	\$1,895.00
		Special Inst:	MACHINE AS PER DWG D2230 REV. G B67826				
2	D2230-3P	LUG	4/22/2011 Yes	100.00 Each	Dart Truck	\$13.6000	\$1,360.00
		Special Inst:	MACHINE AS PER DWG D2230 REV. G B67827				
3	D3235-1P	lug	4/22/2011 Yes	100.00 Each	Dart Truck	\$15.0500	\$1,505.00
		Special Inst:	MACHINE AS PER DWG D3235 REV. A B67831				

PO Total: \$4,760.00



CL

No substitution or deviation without  
consent.  
Certificate of Conformity or Material  
Certification required when applicable

Change Nbr: 2

Change Date: 4/6/2011



20 Terry Fox Drive  
Vankleek Hill, Ontario K0B 1R0  
Tel: (613) 678-3957  
Fax: (613) 678-3956

Delivery Slip No.: 17908  
Date: Apr 14, 2011  
Page: 1

<b>Sold to:</b> Dart Aerospace Ltd. Att Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7	<b>Ship to:</b> Dart Aerospace Ltd Att Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7
<b>Order No.:</b> 13764	<b>Sold By:</b>
<b>Shipped By:</b> your truck	<b>Ship Date:</b>

Description	Unit	Ordered quantity	Shipped quantity	Backorder quantity
D2230-1 Mounting Lug Material supplied by DART. D2423 B63005	Each	100		100
D2230-3 Mounting Lug Material supplied by DART. D2423 B63005	Each	100	55	45
D3235-1 Mounting Lug Material supplied by DART. D2423 B63005	Each	100	85	15
Received by <u>Huang</u>		Thank you for your order!		



## CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, Ont.  
K6A 1K7

SHIPPED TO:

same

<u>QUANTITY</u>	<u>PART NUMBER</u>	<u>PART NAME</u>	<u>P.O. NUMBER</u>
55	D2230-3	Mounting Lug	13764
85	D3235-1	Mounting Lug	13764

MATERIAL: supplied by DART D2423 B63005

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.

  
Shigi Walz

Vankleek Hill, April 14, 2011